

Asap

Work Order ID 102087

\*102087\*

May-23-13 2:31:58 PM

Item ID: D4753-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Doubler

Start Date: 5/23/13

Start Qty: 40.00

\*40\*

Cust Item ID:

Required Date: 5/28/13

Req'd Qty: 40.00

\*40\*

Customer:

Reference:

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4753

A

100

0.00

\*100\*

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D4753

Dwg Rev: REVA

Prog Rev: REVA

2- Use reamer to ream .750" hole as per dwg

3- Deburr if necessary

40

φ

*10/11/13*  
13.05.28

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

40

φ

*10/11/13*  
13.05.28

**\*102087\***

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**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 5/23/13      **Start Qty:** 40.00      **\*40\***

**Cust Item ID:**

**Required Date: 5/28/13      Req'd Qty: 40.00      \*40\***

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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0.00

\*120\*

## HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

## Memo

HAAS CNC vertical machine #1

Machine as per Folio FB163 and Dwg D3506

130

\*130\*

QC

## Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

## Memo

0.00

140

**\*140\***

QC

### Quality Control

QC8- Inspect parts - second check

0.00

## Memo

0.00

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA fat Date: 13/06/13QA Closed: X Date: 13/06/17

Work Order: <u>10208A</u> Part No. <u>D4753-1</u> NCR No. <u>13-2742</u>	<b>DISPOSITION</b> Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b> <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input checked="" type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input checked="" type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input checked="" type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>	13/06/03	20	1	.126 dimension is .110 on 3 pieces due to oversanding the stock size on operation #100.	UP 13/6/3	Acceptable	UP 13/6/3	FE 13/06/04	S 13/6/11
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>	13/06/03	20	1	1 blank is all warped from previous operation due to length of part / vs the length capacity of belt sander between feed rollers.	UP 13/6/3	SCRAP \$14.43	UP 13/6/3	FE 13/06/04	S 13/6/11
Process <input checked="" type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

## FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions
<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		
<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other		

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**\*N900040100\***

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Revision ID:

Stop **\*NS2\***

Item Name: Doubler

Start Date: 5/23/13

Start Qty: 40.00

**\*40\***

Cust Item ID:

Required Date: 5/28/13

Req'd Qty: 40.00

**\*40\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
<b>*150*</b>	Small Fab								
Small Fab	Memo	0.00							
Small Fab	C'sink as per Dwg D4753 (On Flat side)								
160		0.00							
<b>*160*</b>	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
170		0.00							
<b>*170*</b>	Chemical Conversion Coat per QSI005 4.1								
HandFinish	Memo	0.00							
Hand Finishing									

32

3/6/04

21  
1365

39  
can

39 2/13/05

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

QC7-Inspect Chemical Conversion Coat

0.00

\*180\*

QC

Memo

0.00

Quality Control



13-6-6

190

Identify as per dwg & Stock Location: 46

0.00

\*190\*

Packaging

Memo

0.00

Packaging

13-6-6  
39

200

QC21- Final Inspection - Work Order Release

0.00

\*200\*

QC

Memo

0.00

Quality Control

13-06-06

13-06-6

# Picklist Print

May-23-13 2:31:58 PM

Page 1

Work Order ID: 102087

Parent Item: D4753-1

Parent Item Name: Doubler

Start Date: 5/23/13

Required Date: 5/28/13

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP REV:A NEW ISSUE 13-02-21 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No				sf	168.0094		0.60.552	Ac / m	13.05.28	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT021		168.0093578							
				121473		0.9161578							
				123279		72.89							
				<u>125257</u>		94.2032			<u>125257</u>				



